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D3942-1

Job Sheet 202430



Part No: D3942-1

Job Qty: 24 pcs

49
DAS
21
9-89

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/28/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/29/19

Description:

Type: Stock

Note: DWG REV C Ipp Rev:A UPDATE TO REV B 10-11-24 JLM VERIFIED BY:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	24 pcs		11/29/19	0.17	0.55	Waterjet - Flow		OK 19/11/17
120	QC 8	24 pcs		11/29/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		DAS NOV 18 2019 68
							QC 8 - 67		9-89
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - Brake NC - B4B	24 pcs		11/29/19	0.25	0.20	Small Fab - Brake - 1 - B4B		DAS NOV 18 2019 30
							Small Fab - Brake - 2 -		9-89

PRIORITY

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				B4B	
				Small Fab - Brake - 3 - B4B	
140 QC 5	24 pcs	11/29/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS NGV 1 8 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Packaging 3-1 - Stock - B4B	24 pcs	11/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS 28 9-89
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	DAS 21 9-89
				Packaging 3 - 36 - B4B	
160 QC 21 - SA	24	11/29/19	0.00 0.00	QC 21 - SA - 21	NOV 1 9 2019

pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 120 - QC8- Inspect parts - second check
 Descriptions: 130 - small fab - Form as per dwg
 140 - QC5- Inspect part completeness to step on W/O
 150 - Identify as per dwg & Stock Location: _____
 160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S18GA	304/316 .050 Sheet	.3600 sf (.015 ea)	100-Waterjet - Flow - 1	5227406

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S18GA	0	5	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angle	3.060Inches ± 0.030	3.090 3.030		
2	Angle	0.750Inches ± 0.030	0.780 0.720		
3	Angle	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	
4	Angle	0.750Inches ± 0.030	0.780 0.720		
5	Angle	0.250Inches ± 0.030	0.280 0.220		
6	Angle	0.250Inches ± 0.030	0.280 0.220		
7	Angle	0.250Inches ± 0.030	0.280 0.220		
8	Angle	0.340Inches ± 0.030	0.370 0.310		

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

DISPOSITION		DEPARTMENT/PROCESS			
Job: _____	Rework ☐ Scrap ☐ Use-as-is ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			